

Work Order ID 63497

Wednesday, November 03, 2010 10:27:13 A

Page 1

Item ID: D2873-043

Accept

Revision ID:

Item Name: Nut Plate Assembly

Start Date: 11/3/2010 Start Qty: 20.00

Required Date: 11/17/2010 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date: 10-11-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2873

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

aml 10/11/03

20

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-3
Dwg Rev A Folio Rev AA

SL 10/11/08

20

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

[illegible]

Page 3

Accept

Setup Start

Stop

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

0.00

[illegible]

Memo

0.00

Hand Finishing

0.00

|||||

QC

Memo

0.00

Quality Control

0.00

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 ☐ 2-Identify as D2873-043

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 63497

Wednesday, November 03, 2010 10:27:13 A

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Item ID: D2873-043

Accept

Revision ID:

Item Name: Nut Plate Assembly

Start Date: 11/3/2010 Start Qty: 20.00

Required Date: 11/17/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SP 10/16/15

(20)

200

Identify as per dwg & Stock Location: MOJAH

0.00



Packaging

Memo

0.00

Packaging

C 10/16/15 (20)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/15

MF
10-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, November 03, 2010 10:27:17 AM

Page 1

Work Order ID: 63497

Parent Item: D2873-043

Parent Item Name: Nut Plate Ass'n'bly



Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5 Nut Plate		Purchased	No			100	Each	35.0000	3	60			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		35							
					115908	35							
M6061T6B0.375X01.00 0 6061T6 BAR .375 x 1.00		Purchased	No			180	f	27.6952	0.3083	6.490526			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT01		0.45							
					113325	0.45							
				MAT04		27.2452							
				114352		27.2452							
MS20426AD4-6 Rivet		Purchased	No			180	Each	2,602.000	6	120			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST317		2602							
					110139	2602							

Ep 5/10/11/15
M116082 (60x)

6.490 on 10/11/03
Ep 5/10/11/15
120

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	63497
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

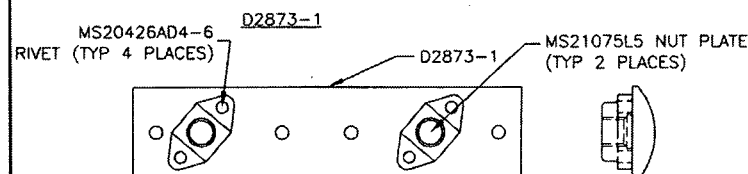
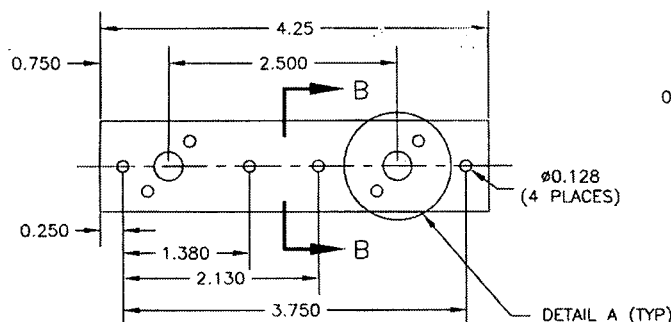
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	—		Vein	ML-7
2.000	+/-0.010	2.000	—		"	"
0.750	+/-0.010	.750	—		"	"
1.000	+/-0.010	1.000	—		"	"
0.250	+/-0.010	.250	—		"	"
1.000	+/-0.010	1.000	—		"	"
2.000	+/-0.010	2.000	—		"	"
3.000	+/-0.010	3.000	—		"	"
Ø0.128	+0.005/-0.001	Ø.130	—		"	"
0.359	+/-0.010	.359	—		"	"
Ø0.316	+0.006/-0.001	Ø.319	—		"	"
1.000	+/-0.010	.999	—		"	"
0.250	+/-0.010	.250	—		"	"
0.061	+/-0.010	.063	—		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.234 x .130	—		"	"

Measured by:	aml	Audited by:	SJ	Prototype Approval:	N/A
Date:	10/11/05	Date:	10/11/15	Date:	N/A

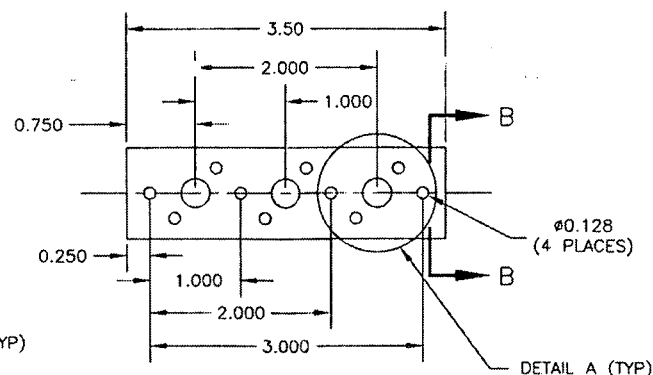
Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	

WITHOUT NOTICE
WORK ORDER

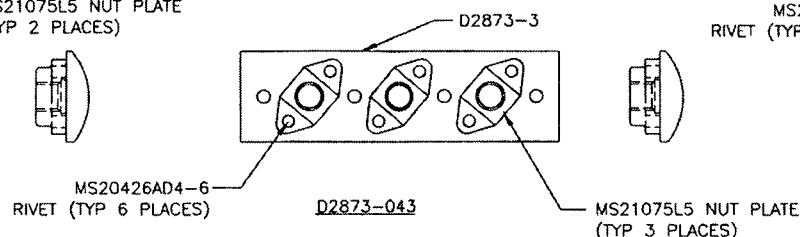
NO. 63497
B/10-11-03



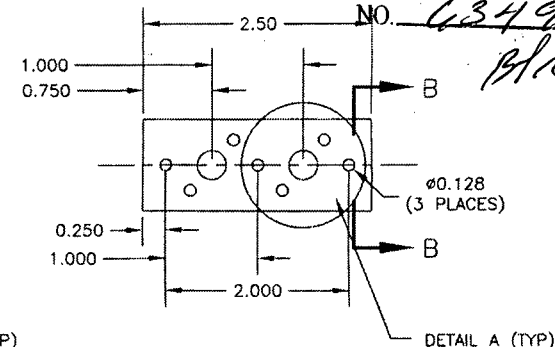
D2873-041



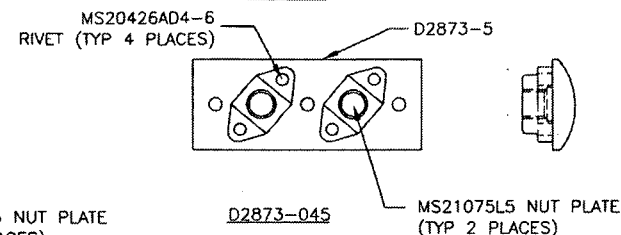
D2873-3



D2873-043



D2873-5



D2873-045

D2873-1/-3/-5 RADIUS BLOCK

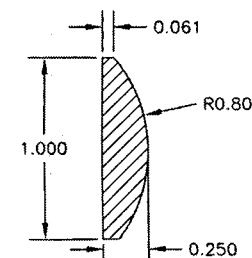
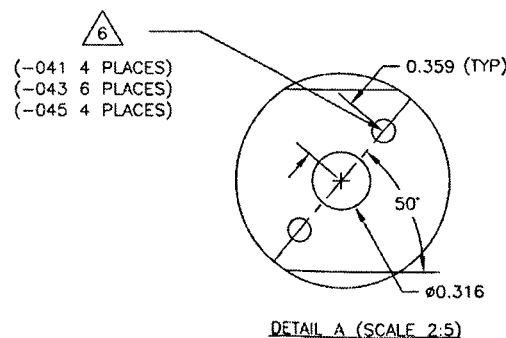
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WARRICKSURY, OXFORD, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:3

W/O:		WORK ORDER CHANGES					
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